IN THE SPECIFICATION

On page 10 at both of lines 5 and 7, please delete the word "indentations" and substitute in place thereof - miter cuts - .

On page 12, line 2, please change "32" to - 34 - .

IN THE CLAIMS

Please amend Claims 2, 3, 4, 6, 7, 8, 11, 13, and 14 as follows:

2. (Amended) A method according to Claim 1 including a plurality of transverse security bars [extending between and into said stile members] and a plurality of upright security bars [extending between and into said rail members], and further comprising forming said stile members and said [transverse] rail members with flat, inwardly directed attachment flanges [across which said security bars pass], positioning said transverse security bars so that they pass across said attachment flanges of said stile members, and positioning said upright security bars so that they pass across said attachment flanges of said rail members wherein said security bars reside in contact with and are spot welded to said attachment flanges across which they pass.

3. (Amended) A method according to Claim 2 further comprising forming and positioning said attachment flanges in mutually coplanar relationship with each other to reside in a common plane and said step of spot welding is performed to attach said transverse security bars [that extend into and between said stile members] to said attachment flanges of said stiles [thereof] on one side of said common plane and said step of spot welding is performed to attach said upright security bars [that extend between and into said transverse rail members] to

said attachment flanges of said rail members [thereof] on the opposite side of said common plane.

4. (Amended) A method according to Claim 2 further comprising first punching security bar receiving openings in at least one flat sheet metal strip and cutting said at least one flat sheet metal strip to form corner securing tabs thereon, roll forming said at least one flat sheet metal strip to form said hollow members at least some of which have pairs of said corner securing tabs projecting therefrom, positioning said hollow members so that said frame has a rectangular configuration forming four corners in which said transverse rail members meet said upright stile members with a pair of said corner securing tabs at each of said corners projecting into an adjacent hollow member, and spot welding said pairs of corner securing tabs [on said at least some hollow members] to [other of said] a hollow member [members] adjacent thereto at each of said corners.

6. (Amended) A method according to Claim 5 further comprising initially cutting spot welding tip access apertures in said single, flat, sheet metal strip, thereby creating at least one spot welding tip access aperture in said hollow members at each of said corners, and spot welding said pairs of corner securing tabs to [said other of] said adjacent hollow members [adjacent thereto] by inserting internal spot welding tips into said spot welding tip access apertures so as to contact said corner securing tabs within said adjacent hollow members, bringing external spot welding tips into external contact with said adjacent hollow members and passing electric currents between said internal and said external spot welding tips to spot weld said hollow members together at each of said corners.

7. (Amended) A method of fabricating a metal security door comprising:

forming four hollow metal door perimeter segment members so as to define a plurality of security bar receiving openings in each of said perimeter segment members,

positioning a plurality of metal security bars to project through said security bar receiving openings and into said hollow perimeter segment members so that said ends of said metal security bars terminate within said perimeter segment members and positioning said perimeter segment members together to form a rectangle, and

spot welding said ends of said metal security bars to said perimeter segment members within which they terminate.

8. (Amended) A method according to Claim 7 further comprising roll forming said hollow segment members so as to create a security bar attachment flange on each of said hollow perimeter segment members, whereby when said perimeter segment members are positioned together to form said rectangle said attachment flanges all project inwardly within said rectangle and lie in a common plane, and whereby said security bar receiving openings in each of said perimeter segment members reside proximate to said security bar attachment flange thereof on one side of said common plane while said security bar receiving openings in each adjacent perimeter segment member lie on the opposite side of said common plane.

11. (Amended) A method according to Claim 7 further comprising forming at least [lest] some of said perimeter segment members with corner tabs projecting from their ends and spot welding said corner tabs to other of said perimeter segment members located adjacent thereto.